

# Work Order ID 71062

Tuesday, June 21, 2011 1:33:25 PM

Page 1

Item ID: D2933-1

Accept

Revision ID:

Item Name: Saddle LH In, 206

Setup Start

Stop

Start Date: 6/21/2011 Start Qty: 4.00

Required Date: 7/8/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2933

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

SL 11-07-18

4

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11-07-18

4

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

SL 11-07-18

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71062

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Item ID:	D2933-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle LH In, 206					
Start Date:	6/21/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	7/8/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

140	• Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

155		0.00							
SprayPaint	Memo	0.00							
Spray Painting	PRIME B 117319 DEFLEET BLUE B 118395 DEFLEET CLEAR B 118053								

29 11.7.18

4

4 6 11.07.19

25 11.07.26 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 71062**

Tuesday, June 21, 2011 1:33:25 PM



Page 3

Item ID: D2933-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 6/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

165



QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

11/7/27 4

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 121

0.00

Memo

0.00

11/7/27 4

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/7/27 4

11/7/27 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 21, 2011 1:33:32 PM

Page 1

Work Order ID: 71062

Parent Item: D2933-1

Parent Item Name: Saddle LH In, 206



Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC  
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001		Manufactured	No			100	Each	49.0000	1	4			
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Saddle Billet



2-11-07-14

Location

Loc Qty

Loc Code

MAT040

44

64777

20

66965

4

69677

20

MAT40

5

69700

5

70976

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>				<b>Work Order:</b>	71062
<b>Description:</b> 206 Saddle, Inboard, Left side				<b>Part Number:</b>	D2933-1
<b>Inspection Dwg:</b> D2933 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.120	.120	.119	.120	
B	0.100	0.140		.120	.120	.120	.120	
C	0.100	0.140		.115	.119	.115	.115	
D	0.210	0.230		.220	.221	.220	.221	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.511	.511	.511	.511	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.257	.257	.257	.257	
L	0.312	0.317		.313	.313	.313	.313	
M	0.235	0.240		.238	.238	.238	.238	
N	0.100	0.140		.121	.120	.121	.120	
O	0.540	0.560		.550	.550	.550	.550	
P	0.490	0.510		.498	.499	.497	.500	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.490	2.490	2.490	2.490	
S	0.240	0.270		.251	.250	.250	.251	
T	0.100	0.180		.140	.140	.140	.140	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.316	.316	.316	.316	
X	1.125	1.145		1.135	1.135	1.135	1.135	
Y	1.565	1.585		1.575	1.575	1.575	1.575	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b> <i>[Signature]</i>	<b>Date:</b> 11-07-18
<b>Audited by:</b> <i>[Signature]</i>	<b>Date:</b> 11-7-18
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	<i>[Signature]</i>

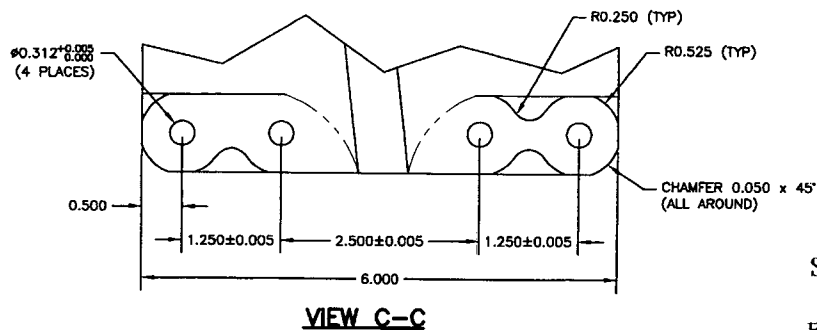
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

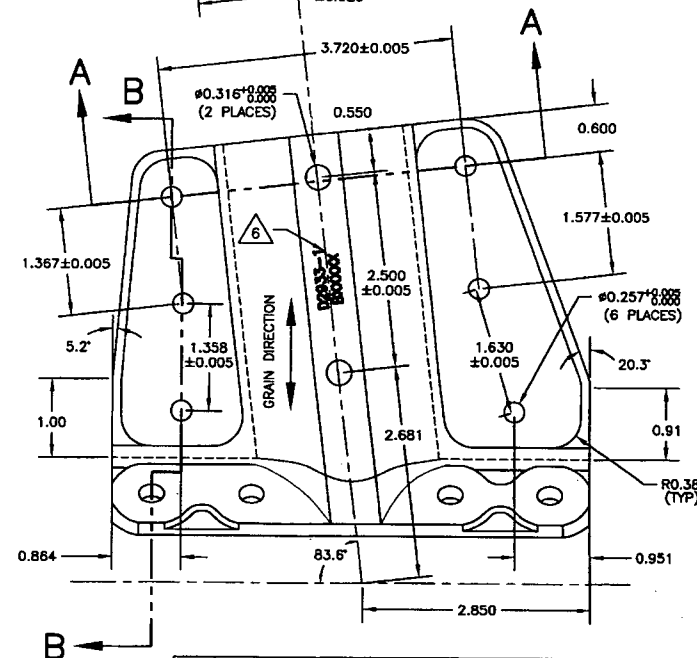
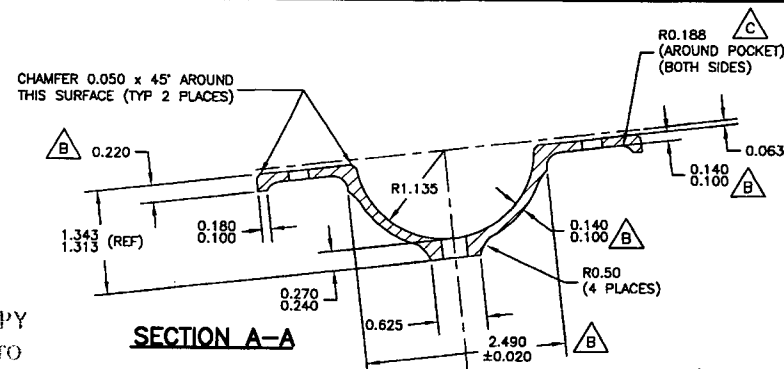
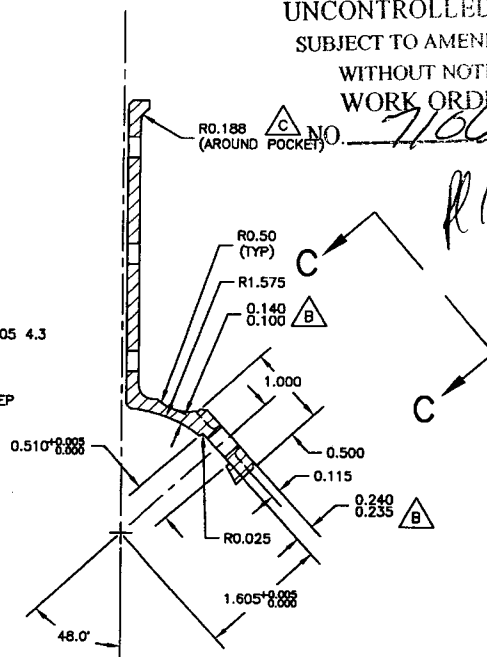
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NOTE: Date & initial all entries



**D2933-1 LH SADDLE (SHOWN)**  
**D2933-2 RH SADDLE (OPPOSITE)**

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
 (MAKE FROM D8101-001 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC.
CHECKED	PH	D2933
DATE	06.11.09	SADDLE INSIDE

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 DART AEROSPACE USA, INC.

REV. C  
 SHEET 1 OF 1  
 SCALE  
 2:3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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